

Date: Monday, 1/14/2008 2:37:00 PM
User: Kim Johnston

Process Sheet

SPiRiT

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: MOUNTING LUG		
Job Number	: 36747			Part Number	: D22301		
Estimate Number	: 10255			Drawing Number	: D2230 REV F		
P.O. Number	:			Project Number	: N/A		
This Issue	: 1/14/2008	S.O. No.	:	Drawing Revision	: F		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: MACHINED PARTS	Due Date	: 2/15/2008		
Previous Run	: 36102			Qty:	200	Um:	Each
Written By	:			60			
Checked & Approved By	: <u>1/14/08 01/15</u>						
Comment	: Est D 00.11.01 Added inspection level 8, and removed P/O for powder coat EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
---------	-----------------------	--------------

1.0	D2423	Lug Extrusion
-----	-------	---------------



Comment: Qty.: 0.0717 f(s)/Unit	Total : 14.3430 f(s)
---------------------------------	----------------------

Lug Extrusion D2423 Extrusion

Batch: <u>533310</u>

<u>c20810115</u>



2.0	BAND SAW	BAND SAW
-----	----------	----------



<u>cut at 0.82"</u>



Comment: BAND SAW

Cut D2423 extrusion to 0.82"

Batch:

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



<u>Issue PO 5448</u>



<u>c20810115 200</u>

Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine per folio D2230-1

(Check for crack while loading into the machine.)

2-Tumble and deburr rough edges after tumbling
--

<u>Machine per folio drage D2230 rev.F</u>
--

RG

QC2



INSPECT PARTS AS THEY COME OFF MACHINE
--

<u>Receive & inspect for bent damage</u>
--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

<u>ensure lot C attached 1/14/29 (60)</u>

RG

QC5



SECOND CHECK

<u>50/4/30</u>



Comment: SECOND CHECK Inspect level 5

<u>counts</u> <u>163</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

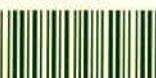
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/02/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/14/2008 2:37:01 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: MOUNTING LUG
Job Number: 36747		Part Number: D22301
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1 
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		JB 8-1-30 (60)
7.0	QC5 	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		✓ 08/01/08 x 60
8.0	POWDER COATING 	POWDER COATING 
Comment: POWDER COATING Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3		M106379 HJ 08-01-31 (60)
9.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT		M. J. 08/01/31 (60)
10.0	PACKAGING 1 	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST. 476		AS 08/02/05 (60)
11.0	QC21 	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		Do 08/02/06
Job Completion 		in 2008/2/05 (60) U

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

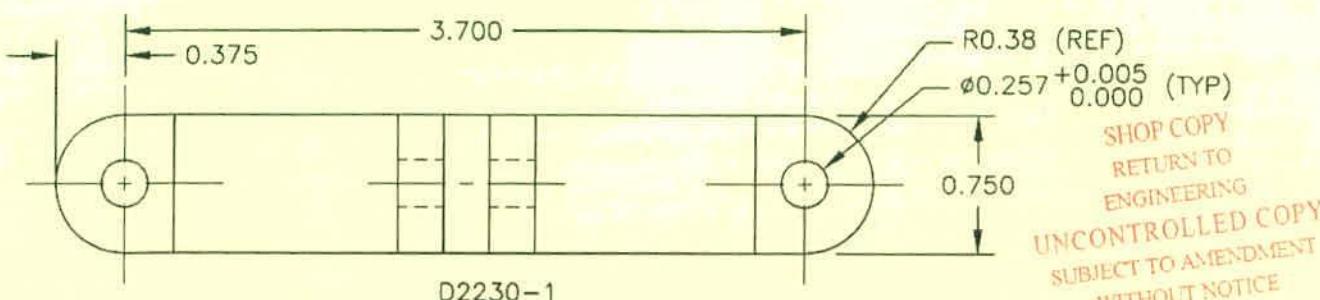
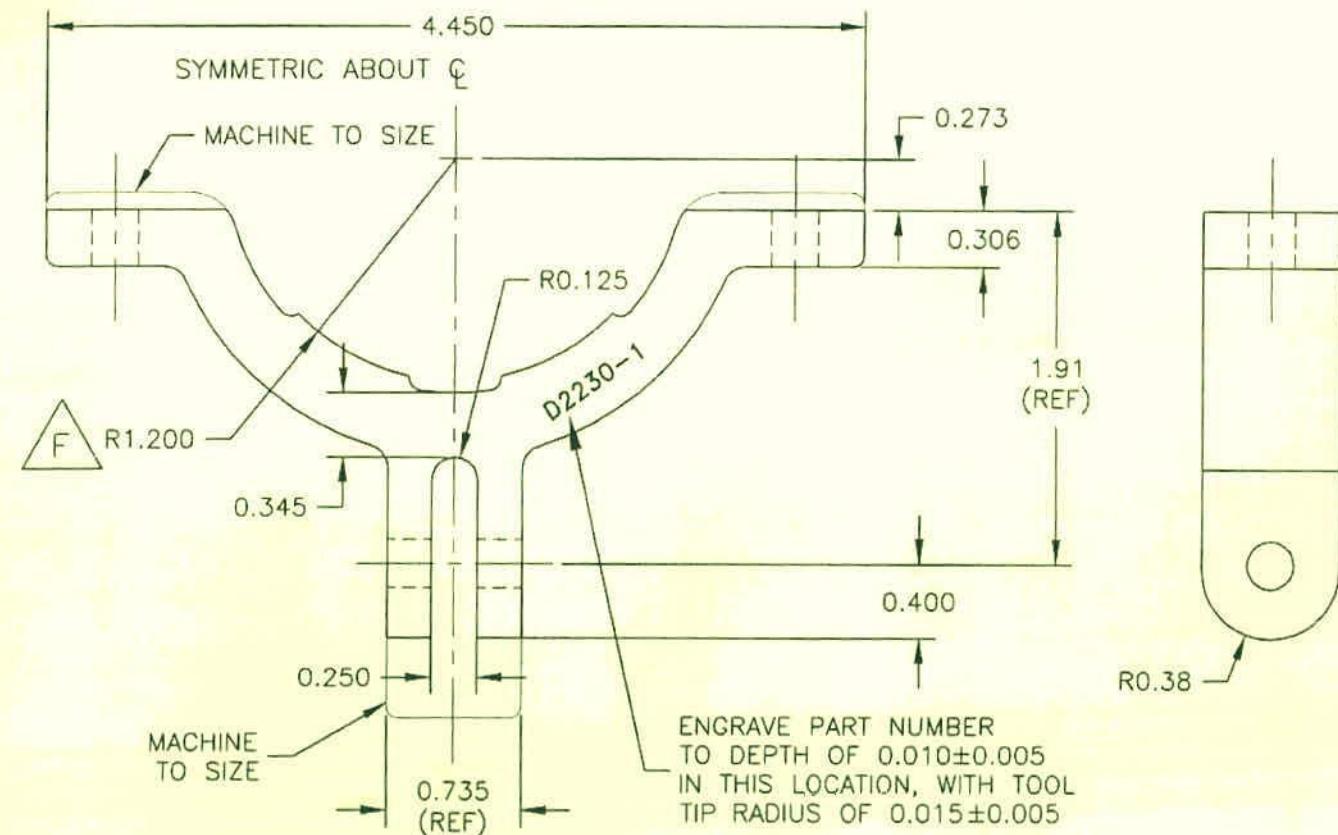
NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2230
DATE		REV. F SHEET 1 OF 2
99.12.13		SCALE 1:1
C	94.03.30	RE-DESIGN
D	95.01.04	RE-DESIGN
E	95.01.04	RE-DESIGN
F	99.12.13	REDESIGN; R1.200 WAS R1.100

RELEASED

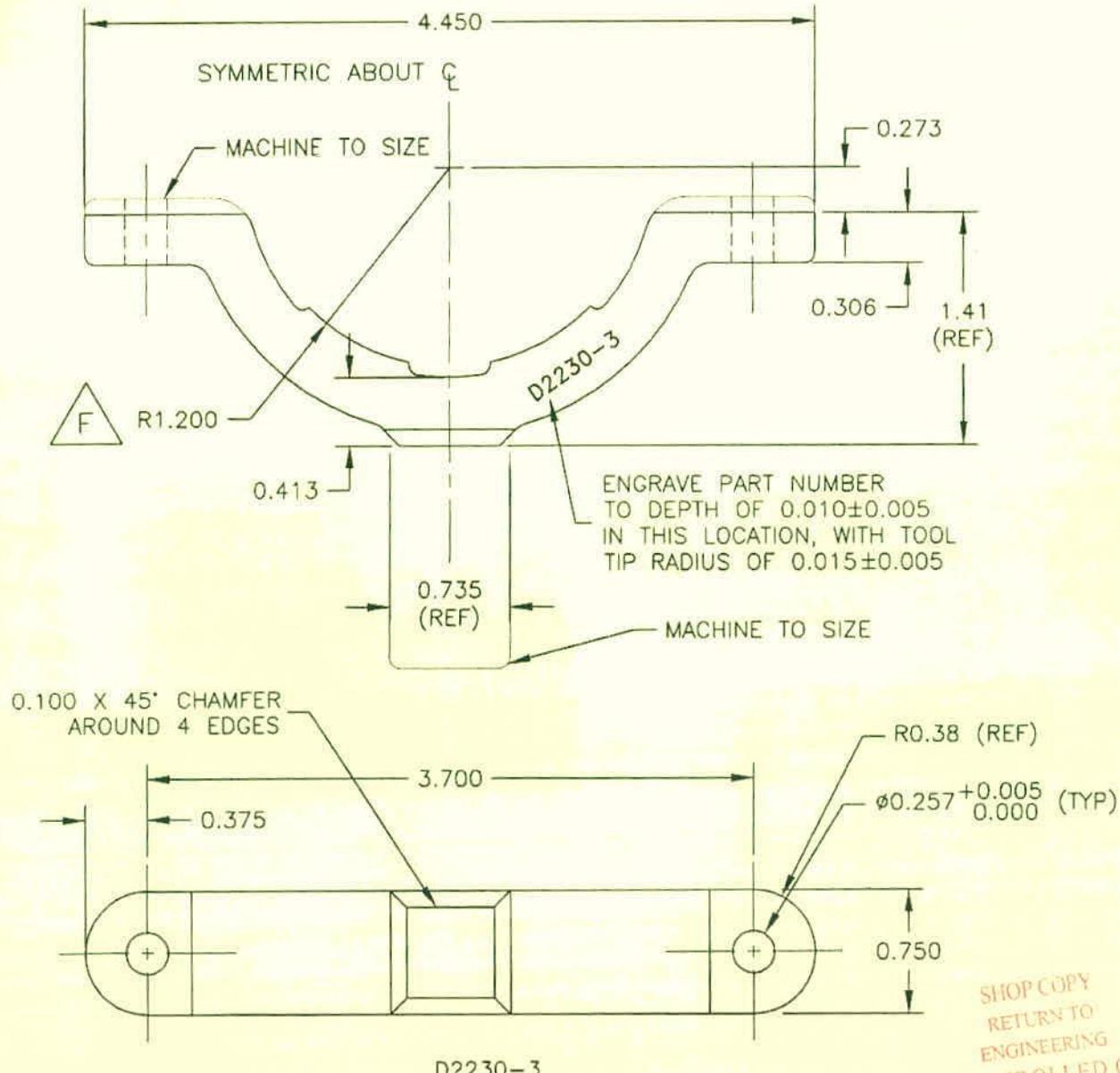
1999.12.21 DS



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DARTCOPY ISSUED
DRAFT

DESIGN	GP	DRAWN BY	GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>✓</i>	APPROVED	<i>✓</i>	DRAWING NO. D2230
DATE	99.12.13			REV. F SHEET 2 OF 2 SCALE 1:1

RELEASED
19.12.21 DS

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALQDINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36747

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
60	D2230-1	Lug B36747	P5448

MATERIAL: supplied by DART D2423 B33310

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi Walz
Shigi Walz

Vankleek Hill, January 29, 2008

